

WORK ORDER 2012-21

Date opened: 30 May 2012

Project: Quick Release Cargo Basket Assembly  
Type: Robinson R44 Series

Batch Quantity: 5 Complete LH Basket Assembly (90610-01-02)

Approval: SH10-48  
Drawing List: DCL906-11, DCL906-12

Fabrication and Assembly Drawing(s)	Description
90610, Rev. 0	Basket Ass'y
90611, Rev. 0	Basket Body Ass'y
90612, Rev. 0	Basket Lid Ass'y
84255, Rev. 1	Handle Installation
84261, Rev. 1	Handle Bar Ass'y
84262, Rev. 1	Handle Bracket Ass'y

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u>
Document Control List revision level matches (or exceeds) STC:	<u>Y</u>
Drawings revision levels match Document Control List:	<u>Y</u>
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u>
Tests and inspections specifically called out on drawings are complete:	<u>Y</u>
Release tags associated with all fabricated parts are attached:	<u>Y</u>
All mounting hardware and supplies are included:	<u>Y</u>

List all non-conformities raised: \_\_\_\_\_

Welder Signature: \_\_\_\_\_ Date: \_\_\_\_\_

Inspector Signature: \_\_\_\_\_ Date: \_\_\_\_\_

Drawing: **90610** Revision 0  
 Assembly: **90610-01** Cargo Basket Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	90610-01-02	LH Cargo Basket Assembly			
. 1	90611-01	Basket Body Assembly	Below		
. 1	90612-01	Basket Lid Assembly	Below		
. 1	84255-01	Handle Bar Installation	Below		
. 1	36280-01	Brace Assembly	9-2081 Brace	12059	
. 1	MS20001P4	Piano Hinge		12066	
. 1	90627-01	Placard	0.063" Sheet, 6061-T6 Aluminum	11102	
. 3	49205-14	Bumper	Argus Industries Bumper	11010	
. A/R	CR3213-5-02	Blind Rivet		12055	
. 8	CR3523-5-02	Monel Blind Rivet		11061	
. 4	CR3213-4-02	Blind Rivet		12032	
. 3	40088-14	Fitting	Ancra	11121	
. 3	AN960-616	Washer		11077	
. 1	90628-01	Fitting		11105	
. 1	AN3-15A	Bolt		12052	
. 1	AN3-17A	Bolt		12052	
. 4	AN960-10	Washer		11114	
. 2	AN970-3	Washer		12032	
. 2	MS21044N3	Nut		12032	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	HR3213-5-02, HR3523-5-02 Rivets		
Final Inspection	Drawing 90610			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 90611 Revision 0  
 Assembly: 90611-01 Basket Body Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	90611-01-02	LH Basket Body Assembly			
. 1	90621-01-02	LH Aft Attachment Hoop			
. . 2	90621-04	Lug	1018 Mild Steel, 5/8" Rod	12056	
. . 1	--	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	12045	
. . 1	--	Tube	4130 Steel, 1" x 0.065 Sqr. Tube	12045	
. 1	90622-01-02	LH Forward Attachment Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	12045	
. . 2	69823-02	Lug	1018 Mild Steel, 5/8" Rod	12056	
. 3	49210-02	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	12045	
. A/R	--	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	12045	
. A/R	--	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	12045	
. 1	84262-01	Handle Bracket Assembly	Below		
. 1	49215-01	Spacer	1018 Steel, 1/2" Rod	12056	
. A/R	3/4-16F	Mesh	Expanded carbon steel	12065	


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 90611			
Final Inspection	Drawing 90611			

Tag incomplete parts with Work Order # when stored between processes.

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Drawing: 90612 Revision 0  
Assembly: 90612-01 Basket Lid Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	90612-01-02	RH Basket Lid Assembly			
. A/R	--	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	12045	
. 1	49216-01	Spacer	1018 Steel, 1/2" Rod	12056	
. 1	84262-01	Upper Handle Bracket Assembly	Below		
. 1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9010	
. A/R	3/4-16F	Mesh	Expanded carbon steel	12065	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 90612			
Final Inspection	Drawing 90612			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.



Drawing: **84255** Revision 1  
Assembly: **84255-01** Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	84255-01	Handle Installation			
. 1	84261-01	Handle Bar Assembly	Below		
. 2	84267-01	Bracket	Delrin, 3/4" Sheet	WO2012-15	
. 2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	12033	
. 2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	11030	
. 2	AN3-14A	Bolt		12032	
. 4	AN3-11A	Bolt		12032	
. 12	AN960-10	Washer		11114	
. 6	MS21044N3	Nut		12032	

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 84255			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **84261**      **Revision 1**  
Assembly: **84261-01**      **Handle Bar Assembly**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	36261-01	Handle Bar Assembly			
. 1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	10083	
. 2	84265-01	Lever	304 Stainless, 0.105 Sheet	10036	
. 2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	11057	
. 2	MS20615-4M3	Monel Rivet		7039	


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84261			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

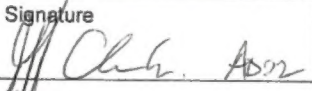
Drawing: **84262**      **Revision 1**  
Assembly: **84262-01**      **Handle Bracket Assembly**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	84261-01	Handle Bracket Assembly			
. 4	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Tube	11049	
. 4	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	10037	
. 2	36275-02	Support	304 Stainless, 5/16" Rod	11093	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L, ER70S-2		
Final Inspection	Drawing 84262			

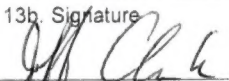
Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO2012-21</b>
6. Item	7. Description <b>LH Cargo Basket</b>	8. Part Number <b>90610-01-02</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>90602-16</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release  <input type="checkbox"/> Other regulation specified in block 12  Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke – AD02</b>		13e. Date (dd/mmm/yyyy) <b>21 Dec 2015</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

ADVANCED AIR



1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.
4. Organization Name and Address <b>AERO Design Ltd. – 2013 39<sup>th</sup> Avenue NE, Calgary, Alberta, T2E 6R7</b>					5. Work Order/Contract/Invoice <b>WO2012-21</b>
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	<b>LH Cargo Basket</b>	<b>90610-01-02</b>	<b>1</b>	<b>90602-11</b>	<b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature		13c. Approved Organization Number		14b. Signature	
		<b>AMF 73-04</b>		<del>14b. Signature</del>	
13d. Name		13e. Date (dd/mm/yyyy)		14c. Approved Organization Number	
<b>Jeff Clarke</b>		<b>21 Aug 2012</b>		<del>14c. Approved Organization Number</del>	
13f. Name		13g. Date (dd/mm/yyyy)		14d. Name	
<del>13f. Name</del>		<del>13g. Date (dd/mm/yyyy)</del>		<del>14d. Name</del>	
13h. Name		13i. Date (dd/mm/yyyy)		14e. Date (dd/mm/yyyy)	
<del>13h. Name</del>		<del>13i. Date (dd/mm/yyyy)</del>		<del>14e. Date (dd/mm/yyyy)</del>	
<b>Installer Responsibilities</b> This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

BAILEY

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.
4. Organization Name and Address <b>AERO Design Ltd. – 2013 39<sup>th</sup> Avenue NE, Calgary, Alberta, T2E 6R7</b>					5. Work Order/Contract/Invoice <b>WO2012-21</b>
6. Item	7. Description	8. Part Number	9. Qty	10. Serial/Batch No.	11. Status/Work
	<b>LH Cargo Basket</b>	<b>90610-01-02</b>	<b>1</b>	<b>90602-12</b>	<b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.			<del>           14a. <input type="checkbox"/> CAR 571.10 Maintenance Release  <input type="checkbox"/> Other regulation specified in block 12.             Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.         </del>		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		<del>14b. Signature</del>	
13d. Name <b>Jeff Clarke</b>		13e. Date (dd/mmm/yyyy) <b>01 Apr 2013</b>		<del>14c. Approved Organization Number</del>	
<del>14d. Name</del>		<del>14e. Date (dd/mmm/yyyy)</del>		<del>14f. Signature</del>	
<b>Installer Responsibilities</b>  This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

PAS 1



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET BODY (R44 LH) No. of pieces: 1

Manufacturer: AERO DESIGN

Part No.: 90611-01-02 Serial / Batch No.: 0/K

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2012-21

Remaining Tasks to be Performed: ASSEMBLY w/ LID

Signature: [Signature]

Date: 09 Aug 2013 Lic. No. / ACA

In Process



**Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**Remarks**

**In Process**

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## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET ASSEMBLY (R44LH) No. of pieces: 1

Manufacturer: AERO DESIGN LTD

Part No.: 90610-01-02 Serial / Batch No.: 90602-14

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2012-21

Remaining Tasks to be Performed: INSTALL HANDLE

Signature: [Signature]

Date: 09 AUG 2013 Lic. No. / ACA

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

Remarks

In Process

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## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET LID (R44 LH) No. of pieces: 1

Manufacturer: AERO DESIGN

Part No.: 90612-01-02 Serial / Batch No.: U/K

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2012-21

Remaining Tasks to be Performed: ASSEMBLY w/ BODY

Signature: JH Chh.

Date: 06 AUG 2013 Lic. No. / ACA

In Process



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

### **Remarks**

**In Process**

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Work Order: 2012-21Material Tracking Sheet  
Robinson R44  
Basket Assembly

1 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		90610-01- <u>02</u>	<b>Cargo Basket Assembly</b>	(-01 RH, -02 LH)	
<b>Step 1</b>				<i>Lid Assembly</i>		
	. 1		90612-01-	Basket Lid Assembly		
Step 1.a.	. . 3		49205-14	Bumper	Argus Industries Bumper	<u>11010</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		90627-01	Placard	0.063 Sheet, 6061-T6 Aluminum	<u>90601-13 s/p 90602-16</u>
	. . 4		CR3213-4-02	Cherry Rivet		<u>14032</u>
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	. 1		90611-01-	Basket Body Assembly		
	. . 3		96710-01	Fitting	Alternate: Ancra 40088-14	<u>13042</u>
	. . 1		90628-01	Fitting		<u>2014-36</u>
	. . 8		NAS1149F0663P	Washer		<u>13084</u>
<b>Step 3</b>				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	54"	<u>13089</u>
	. 8		CR3523-5-02	Cherry Rivet		<u>13026</u>
	. A/R		CR3213-5-02	Cherry Rivet		<u>13026</u>
<b>Step 4</b>	. 1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<u>2014-48</u>
	. . 4		AN3-11A	Bolt		<u>14001</u>
	. . 8		NAS1149F0363P	Washer		<u>14048</u>
	. . 4		MS21044N3	Nut		<u>13083</u>
Step 4.b.	. . 1		84261-01	Handle Assembly		
	. . 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	. . 2		36275-01	Bushing	Brass, 5/16" Dia	<u>13050</u>
	. . 2		AN3-12A	Bolt		<u>13084</u>
	. . 4		NAS1149F0363P	Washer		<u>14048</u>
	. . 2		MS21044N3	Nut		<u>13083</u>

Work Order: 2012-21Material Tracking Sheet  
Robinson R44  
Basket Assembly

2 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
<b>Step 5</b>				<i>Lid Brace Installation</i>		
	. 1		36280-01	Brace Assembly		2014-28
	. 1		AN3-15A	Bolt		13054
	. 1		AN3-17A	Bolt		13084
	. 2		AN970-3	Washer		13053
	. 3		NAS1149F0363P	Washer		14048
	. 2		MS21044N3	Nut		13083
<b>Step 6</b>				<i>Inspection</i>	None	

## CARGO BASKET ASSEMBLY - COMMON

R44 LH  
2012-21

### General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407** – Right side only

69810, Revision 3 – Standard Low Mounted Basket  
94510, Revision 0 – Extra-Wide Low Mounted Basket  
94610, Revision 0 – Extra-Wide Low Mounted Ski Basket  
76610, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355** – left or right

77610, Revision 1 – Short Basket  
76410, Revision 3 – Medium Basket (left or right)  
78410, Revision 2 – Long Basket  
94010, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44** – left or right

→ 90610, Revision 0 – Standard Basket (left or right)

#### **Bell 206B** – right side only

80210, Revision 0 – Short Basket  
80310, Revision 0 – Medium Basket  
81110, Revision 0 – Long Basket

#### **Bell 429** – right or left

95911, Revision 0 – Standard Basket

#### **Bell Medium** – left or right

75111, Revision 0 – Standard Basket  
95511, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82811, Revision 0 – Standard Basket

#### Options

70405, Revision 3? – Lid Walkway

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

Work Order: 2012-21

Date Open: \_\_\_\_\_

### 1. Lid Assembly

4086

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

### 2. Body Assembly

4086

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
  - v. Torque to ??



- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
  - i. Locate 94621-01 Brace over aft cross tube cutout
  - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

## 3. Hinge Installation

A206

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 784 – 90"
    - 5. 940, 946, 959 – 95"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations

- d. Record PO of hinge and rivets on attached material tracking list.

#### 4. Install Handle

ADOC

- a. Install handle brackets.
- Set 84267-01 handle bracket on provisions in hoops, 2 places.
  - Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
  - Torque AN3 bolts to ??.
- b. Install handle
- Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
  - Grease two 36275-01 bushings with ???. Insert into bushings of handle assembly.
  - Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
  - On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
  - At first end, remove bolt and repeat step iv.
  - Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
  - Torque AN3 bolts to ??.
- c. Check handle
- Operate handle to ensure handle does not bind and springs hold handle in.
  - Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

#### 5. Install lid brace

ADOC

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

## CARGO BASKET ASSEMBLY - COMMON

**Complete**  
(initial or SCA #)

✱ \_\_\_\_\_

### 6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.